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D2274**Job Sheet 190973****Part No:** D2274**Job Qty:** 220 pcs**Part Name:** Radius Block**Part Weight:** 0 lbs**Job Created:** 2/20/19**Due Date:** 3/5/19**Type:** SOLD**Status:** New**Priority:** Medium**Job Tracking No:****Created By:** Marie Lajeunesse**Description:****Note:** DWG REV F IPP H 00.05.18 Added inspection level 8 EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Shear - 1	220 pcs	3/5/19		0.00	0.11	Shear - 1		mark 19/02/24
105	Waterjet Flow - B4B	220 pcs	3/5/19		0.00	11.00	Waterjet - Flow - B4B		not required
110	HAAS 4 Axis - B4B	220 pcs	3/5/19		0.01	5.27	HAAS - 1 - B4B		
							HAAS - 2 - B4B		30.1.19-02-26
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	220 pcs	3/5/19		0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		B.p 19-02-26
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
140	Small Fab - 2 - B4B	220 pcs	3/5/19		0.00	1.19	Small Fab - 1 - B4B		ca 19/02/28
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		

**Container No:** S155948**Part:** D2274**Job No:** 190973**Serial No/Batch:** S155948**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Date: 02/24/19

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150	Handfinish - 1-1 Chemical-B4B	220 pcs	3/5/19	0.00 0.56	Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R 19/02/28
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	QC 7	220 pcs	3/5/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	

				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	DAS 40
				QC 7 - 68	9-89
				QC 7 - 50	9-89
				QC 7 - 67	
170	Packaging 3-1 - Stock - B4B	220 pcs	3/5/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B

DAS
40
9-89DAS
9
9-89

19/02/28

					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	220 pcs	3/5/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21 MAR 01 2019
					QC 21 - SA - 53	9-85

Part Op **100** - (Shear) blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces
 Descriptions: **105** - (Waterjet - Flow) CUT BLANK blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces
110 - (HAAS CNC vertical machine #1) Machine as per folio D2274
130 - (QC8- Inspect parts - second check)
140 - (Small Fab) Tumble Deburr any rough edges after tumbling
150 - (Chemical Conversion Coat per QSI005 4.1)
160 - (QC7-Inspect Chemical Conversion Coat)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X00.125	6061-T6 Bar .750 X .125	18.2600 ft (.083 ea)	100-Shear - 1	<u>5138867 = 19.92</u>
M6061T6S.125	6061-T6 .125 Sheet	1.3200 sf (.006 ea)	105-Waterjet - Flow - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Shear - 1	M6061T6B0.750X00.125	18	52	0
105-Waterjet - Flow - B4B	M6061T6S.125	1	50	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Radius Block	0.257inches	+ 0.005 - 0.000	0.262 0.257	
2	Radius Block	0.750inches ± 0.010	0.760 0.740		
3	Radius Block	0.375inches ± 0.010	0.385 0.365		
4	Radius Block	0.125inches ± 0.010	0.135 0.115		
5	Radius Block	0.750inches ± 0.010	0.760 0.740		
6	Radius Block	0.063inches ± 0.010	0.073 0.053		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					